



HEIDENHAIN

Lotse



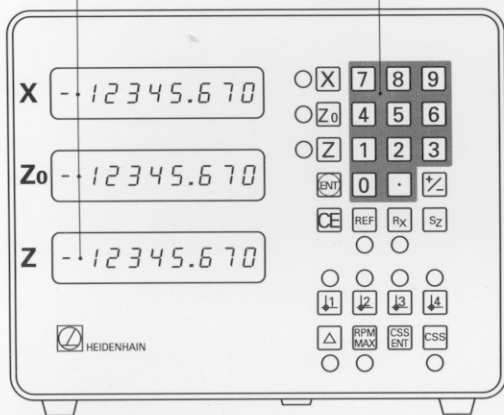
Arbeiten mit dem

VRZ 739/779

Tasten und Anzeigen

Istwert-/Eingabe-Anzeigen

Zehner-Tastatur



Achsanwahl



Eingabe übernehmen



Eingabe löschen/
Parameter-Anwahl



Bezugspunkte



mm/inch-Umschaltung
(wählbar über Parameter P10)



Restweg-Anzeige
(Fahren auf Null)



Referenzmarken-
Auswertung



Radius-/
Durchmesser-Anzeige



Einzel-/Summen-Anzeige
(Bett- und Oberschlitten)

RPM
MAX

CSS
ENT

CSS

CSS-Funktionen

Tasten und Anzeigen

Einschalten/REF-Betrieb

Bezugspunkte

Bezugspunkt setzen

Radius-/Durchmesser-Anzeige

Absolutmaße/Kettenmaße

Positionieren im Kettenmaß

Restweg-Anzeige/Fahren auf Null

Fahren auf Null (Fortsetzung)

Summen-Anzeige (VRZ 779)

Beispiel Summen-Anzeige (VRZ 779)

CSS-Funktionen

Parameter-Eingabe

· mm/inch · Schwindmaß · Anzeige nullen

Fehlermeldungen

Supplement to: - Operating Instructions VRZ 739 / VRZ 779 (10/93) - Pilot VRZ 739 / VRZ 779 (10/93)

New functions starting with software number 246 042 06



Expanded CSS function

In CSS mode the speed of the spindle is controlled in dependency on the position of the X axis slide such that the cutting speed at the workpiece surface remains constant (**C**onstant **S**urface **S**peed).


If parameter P32.0 is given the value 2, the VRZ will behave as follows in CSS mode:

Set the maximum speed (as previously)

Define the first machining speed

- Move to the X position (this position must be positive)
- Select the spindle speed for machining for this X position
- Save the settings with  and . The green LED is on.
The red LED is off.




The spindle speed is controlled in dependency on the X position.

Maximum spindle speed = stored value with 

Minimum spindle speed = P21.0 to P23.0

The spindle potentiometer is inhibited. Speed monitoring is active. If the limit value for the spindle speed is exceeded, an EMERGENCY STOP is performed. The spindle can be disengaged. (Speed monitoring is inactive if the spindle is disengaged). If a gear change is carried out, an EMERGENCY STOP will occur.

Define further machining speeds

- Set the spindle potentiometer to zero.
- Press . The green LED blinks. The red LED is off.
- Move to the X position (this position must be positive)
- Select the spindle speed for machining for this X position.
- Store the set values with  and . The green LED is on.
The red LED is off.

This process can be repeated for datum points 3 and 4.

Four different machining speeds can thus be stored. You switch from one machining speed to another with the datum point keys. If a datum point is selected for which no machining speed has been defined, the error message ERROR 20 is generated.

Leave CSS mode (as previously)

Speed ranges P21 to P26

The input range for parameters P21 to P26 has been increased to **0 to 30 000** revolutions per minute.